

Date: Friday, 13/02/2009 1:02:41 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 45798	
Estimate Number : 10348	
P.O. Number :	Part Number : D28581
This Issue : 13/02/2009 S.O. No. :	Drawing Number : D2858 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 43364	Material :
Written By :	Due Date : 20/02/2009
Checked & Approved By : <u>JUD 09.02.13</u>	Qty: 243 Um: Each
Comment : Est C 00.06.22 Removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01250	6061-T6 Bar 1.50 x 1.25
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Scrap 7"

Comment: Qty.: 0.1767 f(s)/Unit Total : 42.9417 f(s)
 Material: 1.50" X 1.25"
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
 (M6061T6B15001250)
 Batch M107461

88 09/02/13

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 6.02"
 Note: 1 Blank Makes 3 Parts

88 09/02/13

(8)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine per folio D2858-
 2-Deburr as per Dwg D2858000

mmf 09/02/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: HINGE BRACKET

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



30

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mm 09/02/19

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 09/02/20

30

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

FL 09/02/23

30

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

11109996

START TIME: 10:20AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 10:50AM

HS

09-02-24

30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 09-02-24

30

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

19/2/25 (30)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/25

Job Completion



11 09-02-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45798
Description: Hinge Bracket		Part Number: D2858-1
Inspection Dwg: D2858	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

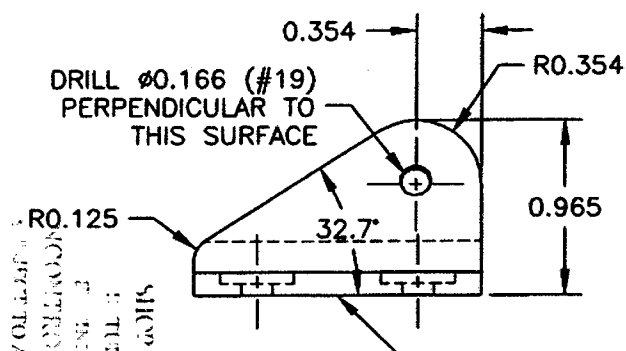
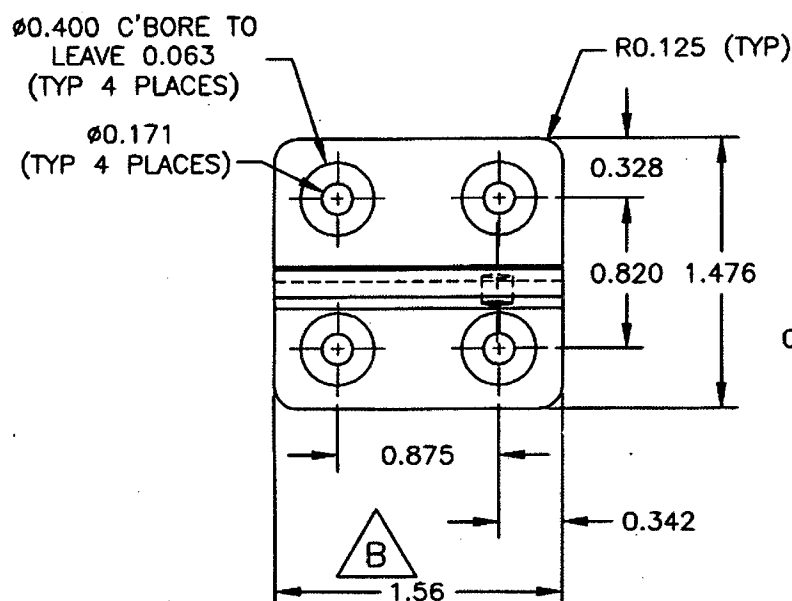
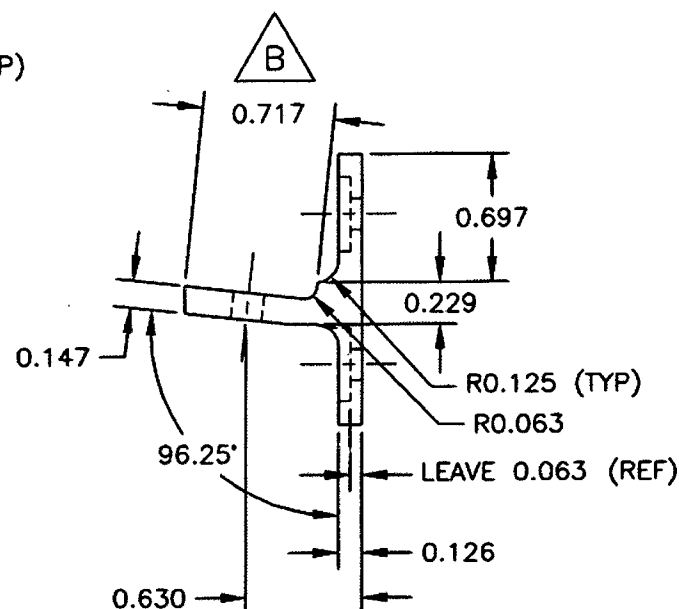
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.001	Ø.174	✓			
Ø0.400	+0.006/-0.001	Ø.400	✓			
R0.125	+/-0.010	R.125	✓			
0.328	+/-0.010	.327	✓			
0.820	+/-0.005	.820	✓			
1.476	+/-0.010	1.475	✓			
0.342	+/-0.010	.340	✓			
0.875	+/-0.005	.875	✓			
1.56	+/-0.030	1.57	✓			
0.147	+/-0.010	.149	✓			
0.717	+/-0.010	.717	✓			
0.697	+/-0.010	.696	✓			
0.229	+/-0.010	.229	✓			
R0.125	+/-0.010	R.125	✓			
R0.063	+/-0.010	R.063	✓			
0.063	+/-0.010	.059	✓			
0.126	+/-0.010	.123	✓			
0.630	+/-0.010	.630	✓			
R0.354	+/-0.010	R.354				
0.965	+/-0.010	.969	✓			
Ø0.166	+0.005/-0.001	Ø.167	✓			
R0.125	+/-0.010	R.125	✓			
32.7°	+/-0.5°	32.7°	✓			

Measured by: mwf	Audited by: JA	Prototype Approval:	N/A
Date: 09/02/19	Date: 09/02/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.30	New Issue	KJ/EC/DD	JA

DART**RELEASED**
99.07.09 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
UP	KE	D2858
DATE	TITLE	SHEET 1 OF 1
99.02.28	HINGE BRACKET	1:1
A	NEW ISSUE	REV. B
98.12.14		
B	0.717 WAS 0.667, 1.56 WAS 1.559	
99.02.28		

ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)**D2858-1 SHOWN**
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED